




Work Order ID 67748

Wednesday, March 30, 2011 8:57:01 AM

Page 1

Item ID: D3675-5 Accept  Setup Start 
Revision ID: Stop 
Item Name: Sliding Door Bracket
Start Date: 3/30/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/31/2011 Req'd Qty: 1.00  Customer:
Reference:


Approvals: Process Plan: AK Date: 11-03-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3675	<u>CD</u>	<u>9CN11-531</u>							

100		0.00							
-----	--	------	--	--	--	--	--	--	--

	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3675								
<u>304, 040</u>	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								

B11-3-30


①

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

									
QC	Memo	0.00							
Quality Control									

B11-3-30

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

									
QC	Memo	0.00							
Quality Control									

Inspector to Rev D
Can release! Dwg only

8/10/30

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67748

Wednesday, March 30, 2011 8:57:01 AM



Page 3

Item ID: D3675-5

Accept



Setup Start



Revision ID:

Item Name: Sliding Door Bracket

Stop



Start Date: 3/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/05/11

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

2363

1 0 4/3/31

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1 0 11/3/31
MF
11-03-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 8:57:07 AM

Page 1

Work Order ID: 67748

Parent Item: D3675-5

Parent Item Name: Sliding Door Bracket



Start Date: 3/30/2011

Required Date: 3/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.11 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

109.0000

0.4092

0.430737



304/316 .040 Sheet



B11-3-30

Location

Loc Qty

Loc Code

MAT020

109

115953

1

116437

44

116623

64

115953

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

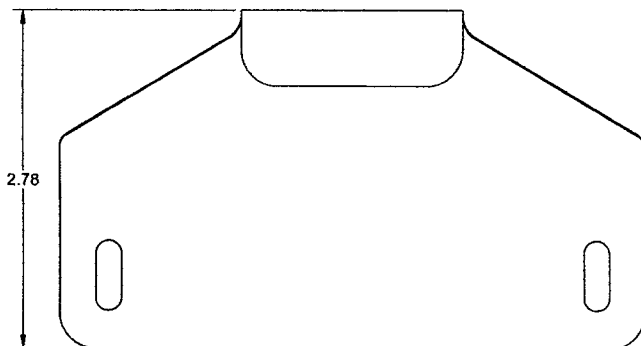
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

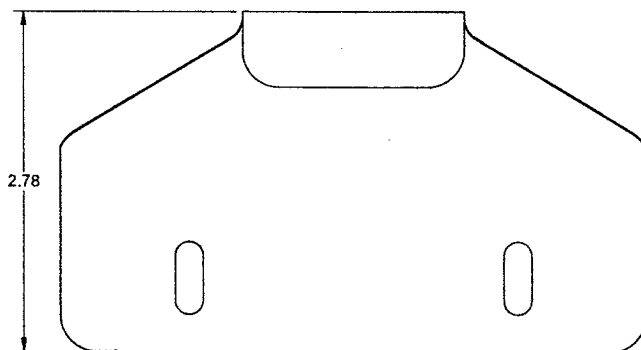
NOTE: Date & initial all entries



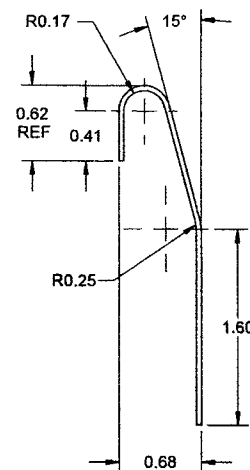
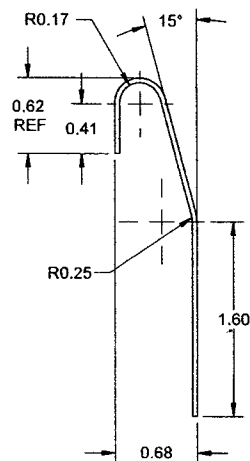
D	RE-DESIGNED D3675-5/6-5F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-78.	MB	11.03.21
C	ADD -5/5F-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AJS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3675 REV. I OF _____ SHEET 1 OF _____ TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR) SCALE _____ DE APPR. _____ NTS _____ DATE 11.03.21	
DRAWN	<i>AJS</i>		
CHECKED	<i>AJS</i>		
MFG. APPR.	<i>MD</i>		
APPROVED	<i>MD</i>		
DE APPR.			
COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD			



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



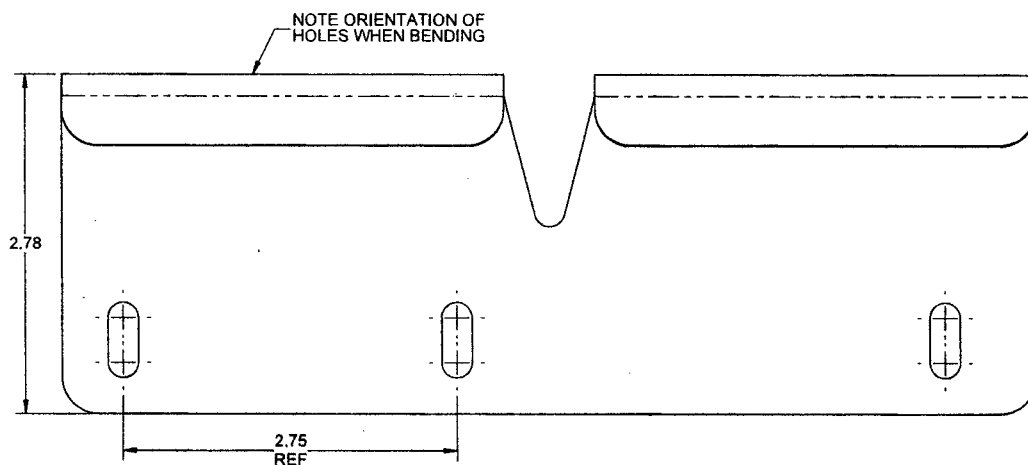
D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



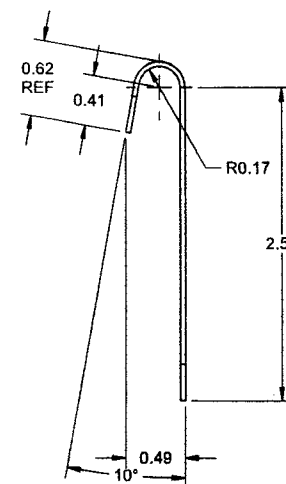
NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

DESIGN	<i>AJS</i>	DART AEROSPACE LTD	
DRAWN	<i>AJS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3675	SHEET 2 OF 6
APPROVED	<i>NO</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.			(COMPOSITE DOOR)
DATE	11.03.21	SCALE	NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



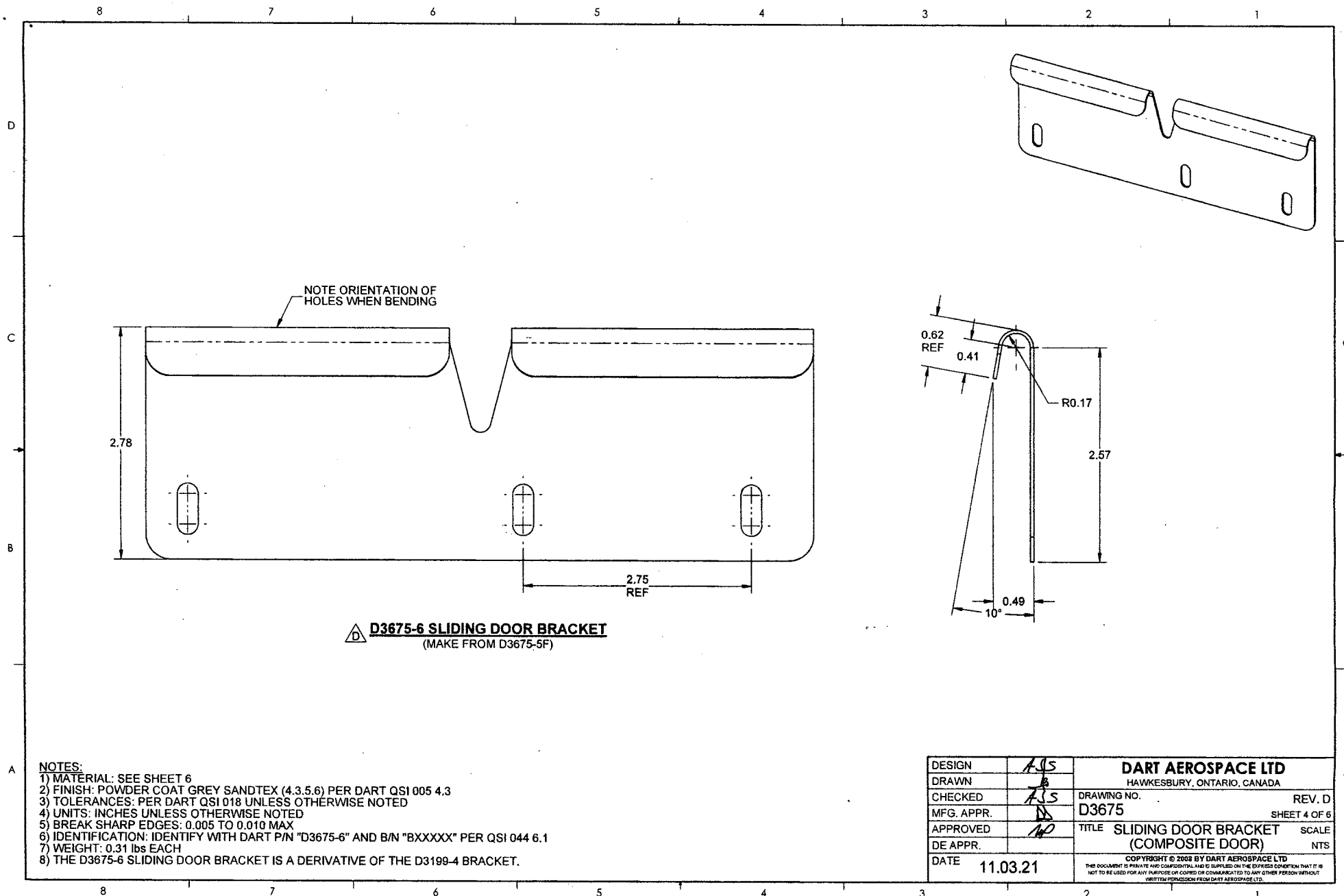
D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 3 OF 6
APPROVED	AD	TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
DATE	11.03.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

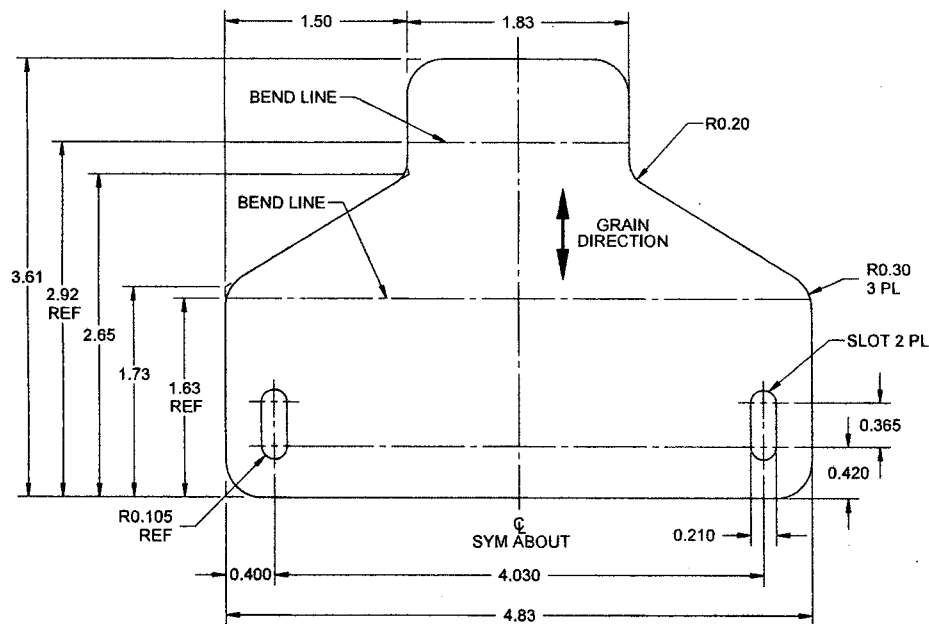


D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)

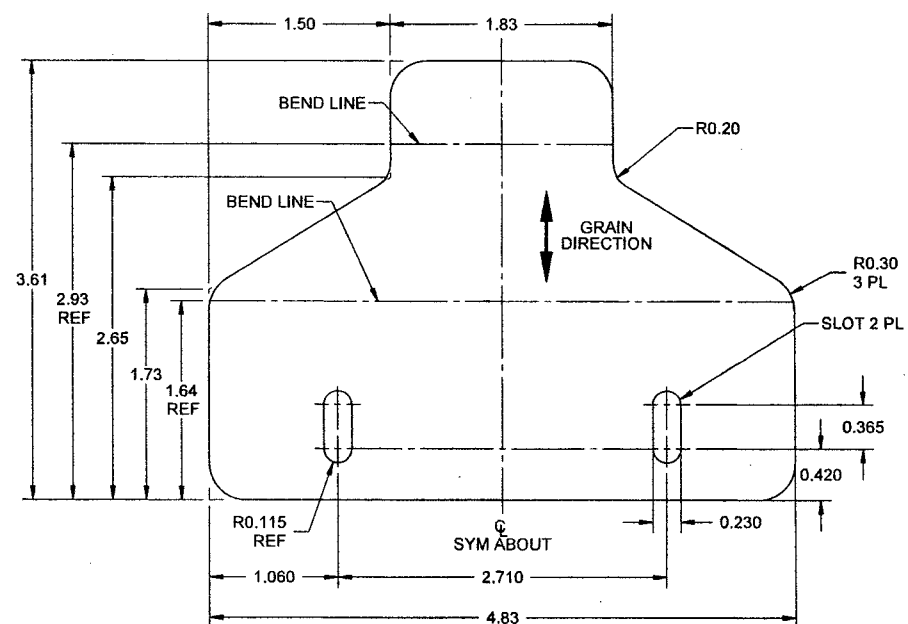
NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AD	D3675	SHEET 4 OF 6
APPROVED	AD	TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	11.03.21	NTS	
COPYRIGHT © 2008 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3675-1F FLAT PATTERN

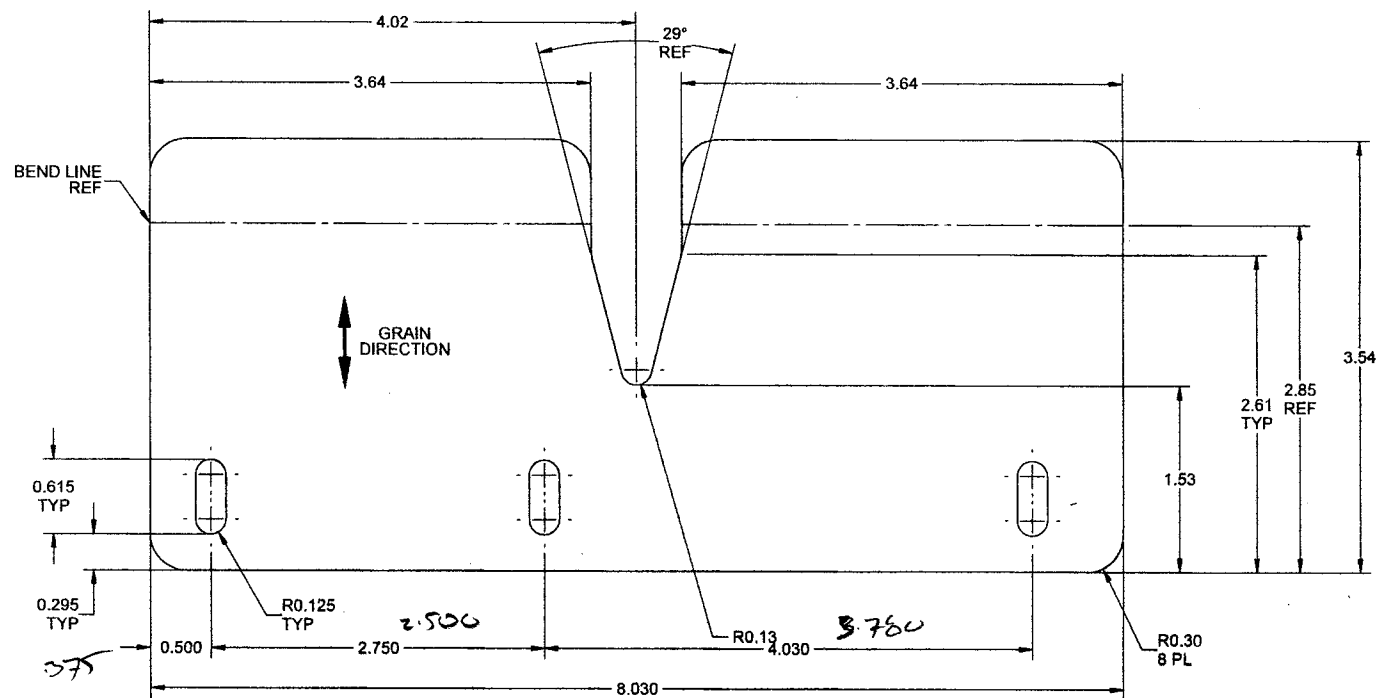


D3675-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3675	SHEET 5 OF 6
APPROVED	AS	TITLE	SCALE
DE APPR.		SLIDING DOOR BRACKET (COMPOSITE DOOR)	NTS
DATE	11.03.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3675-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	<i>AJS</i>	DART AEROSPACE LTD	
DRAWN	<i>AJS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AJS</i>	D3675	SHEET 6 OF 6
APPROVED	<i>AJS</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 67748
Description: Sliding Door BRACKET		Part Number: D3675-5
Inspection Dwg: D3675-5, Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.295	± .010	.296	✓		Vern HB-02	
.500	± .010	.500	✓		"	
.615	± .010	.615	✓		"	
2.750	± .010	2.749	✓		"	
4.030	± .010	4.027	✓		"	
8.030	± .010	8.020	✓		"	
1.53	± .030	1.527	✓		"	
3.54	± .030	3.548	✓		"	
3.78	± .030	/ / / / /				
3.50	± .030					
3.80	± .030					
.040	± .010	.037	✓		"	
3.64	± .030	3.636	✓		"	
4.02	± .030	4.014	✓		"	

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-3-36	Date: 11/03/60	Date:
to Rev D only		
Rev A	Date	Change
		New Issue
Revised by	Approved	
KJ/JLM		

DART AEROSPACE LTD		Work Order:	67748
Description: D3675 Sliding Door Bracket		Part Number:	D3675-5
Inspection Dwg: D3675 Rev: Rev D		Page 1 of 1	

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>JS</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11/03/31</i>	Date: <i>11/03/31</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	